Work Orde November-21-1				*109	9440*						Page 1	
Item ID: Revision ID: Item Name:	D3912-3 Eyebolt Block			Accept	*N900	040	100)* s	etup Sta	iv	S1* S2*	
Start Date: Required Date: Reference:	11/21/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item Customer:						.	· •
Approvals:	Process Pla	in: MLJ	Date: 13-11-25	Tooling:	D	ate:	_	R	Run Sta	171	R1*	
			Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr										
D3912	В										·-	
*100 *100* Bandsaw		Cut blanks as per folio Memo		0.00				12	φ		JFC 20	13-11-27
Jeaspa Bandsaw	·	CUT BLAN	NK 2.50" LONG									
110				0.00		,						
110 HAAS I HAAS CNC vertica	al machine #1	Memo MACHINE FOLIO RE DWG REV			5 L 13/11	/28		_12	S			
		DEBURR										

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DQA:			Date:			-								
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE				AEROSPACE
QA Closed:		i	Date:								W	ork Order up	date only	·
						DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Work Orde	er: .	-					,					1	_	, l
Davit A						Rework			Skid-tube	Crosstube	_	D	Water Jet	Engineering
Part N	NO.					Scrap Use-as-is			Machining noforming	Small Fab Finishing	-	ł	d. Eng. Coor.	Quality Other
NCR I	No.					Suspected Unapproved		men	Large Fab	Composite	-	Nec/Stoi	re/Packaging Supplier	
IVERT	v O.					Suspected Onapproved	1		Large rab	Composite	L	l	2upplier	
Root					Desc	ription of work order update		nitial	Act	ion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design														
Doc/Data												ļ		
Equip/Tooling														
Handling/Pre	Ш													
Material													:	
Operator														
Offset/Setup		,					l					<u>.</u>		
Process														
Supplier														
Training							İ						•	
Transport	igwdap													
Unapproved	Ŀ								ECODY.					
Landi	(General	FA	ULI CA	TEGORY					
Lanui	lig (Bending				Bend			rogram			Outside Dim	encions [Pressure/Forced
	\vdash		ot Concen	ntric	-	BOM/Route		Grain	ТОБГАПП		-	Over/Under	-	Set-up
		Cracks	or concen		-	Broken/Damage/Defect	-	Hardwa	re		-	Part Incorre	 -	Temperature/Cure
	\vdash	1	nk/Ripple,	/Wave	+	Burrs	\vdash	4	ion Incomplete/Ur	ngualified		Part Lost/Mi	-	Weld
	\vdash	Cuffs		,		Contamination	H	1	ions Incomplete/l	-	\vdash	Part Moved		Wrong Stock Pulled
	Г	Crushing				Countersink	-	-i	ned/off center		Г	Positioned V	∟∟ Vrong	
		Heat Trea				Cut Too Short		Mislabe				Power Loss/	_	Other
		Inspectio		Tube		Drawing		Misrea				•	- L	
		Marks/Cl	-			Drill Holes		Off-set						· .
	Г	Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	vist in Tub	e		Fit/Function		Out of	Sequence					

Work Order ID 109440

Packaging

Packaging

109440

Page 2

November-21-13 2:27:52 PM Item ID: D3912-3 Accept *N900040100* Setup Start Revision ID: Item Name: Eyebolt Block *12* **Start Oty: 12.00** Start Date: 11/21/13 **Cust Item ID:** Req'd Oty: 12.00 Required Date: 11/21/13 *12* **Customer:** Reference: Run Process Plan: _____ Date: ____ Tooling: Date: Approvals: Stop SPC (Y/N): OC: Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Number Stamp Qty Qty Description Code **Run Hours** QC2- Inspect parts off machine FAI/FAIB 120 0.00 al 13/11/28 *120* 0.00 OC! Memo Quality Control 401 1100 130 QC8- Inspect parts - second check 0.00 *130* 0.00 QC Memo Quality Control Identify as per dwg & Stock Location: 57/44 160 121 _____131 *160*

0.00

Memo

DAS 26 9-89

DQA:		·	Date:						_						
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		\Mor	k Order up	ndate only	\neg	AEROSPACE
QA Closeu.		1	Date.									·	<u> </u>		
Work Orde	er:					DISPOSITION				AGAINST [DEP	ARTMENT,	/PROCESS		į
	-	:				Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.					Scrap	ı		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging	_	Other
NCR I	۱o. -	· · · · · · · · · · · · · · · · · · ·				Suspected Unapproved			Large Fab	Composite			Supplier		
Root	1				Desc	ription of work order update	Н	Initial	Acti	ion	Т	Sign &		1	
Cause		Date	Step	Qty		or non-conformance		ief Eng				Date	Verification		QC Inspector
Design		;				100 0 000				<u></u>					
Doc/Data]					Í	
Equip/Tooling				·											
Handling/Pre															
Material															
Operator				1											
Offset/Setup															
Process		,													
Supplier															
Training	Ш														
Transport	Ш			į			Ì							ı	
Unapproved				<u> </u>					<u> </u>						
							FA	ULT CA	TEGORY						
Landi	ng (Gear			_	General		7					_	_	
		Bending				Bend		-1	Program			Outside Dim	<u> </u>	-	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		-		over/Under	<u>-</u>	_	Set-up
	$oxed{oxed}$	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>		art Incorre	⊢	_	Temperature/Cure
	_	Crimp/Kir	nk/Ripple	/Wave		Burrs	<u>_</u>	 	ion Incomplete/Un	· .	_	art Lost/Mi	ssing		Weld
	$ldsymbol{le}}}}}}$	Cuffs			<u> </u>	Contamination	<u> </u>	-	tions Incomplete/L	Jnclear	_	art Moved	L		Wrong Stock Pulled
	<u> </u>	Crushing			\vdash	Countersink	L	- '	gned/off center		_	ositioned V			
	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislab		į		ower Loss/	Surge		Other
	-	Inspectio	-	Tube	<u> </u>	Drawing		Misrea			_				
	<u></u>	Marks/Cl			_	Drill Holes		Off-set			_	 .			
		Turning S			igspace	Finish	_	-	Calibration		_				
1	[Wave/Tw	ist in Tub	oe -		Fit/Function		Out of	Sequence						

November-21-13 2:27:52 PM

Required Date: 11/21/13

Item ID:

D3912-3

11/21/13

Accept

N900040100

Setup Start

Revision ID:

Item Name: **Start Date:**

Eyebolt Block

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

Date:

Date:

Run Start

Stop

Stop

Sequence ID/ Work Center ID

Operation Description

Set Up/ **Run Hours** **Tool ID**

Tool # Plan Code

Accept Qty

Reject Reject Number Stamp

Insp.

170

QC21- Final Inspection - Work Order Release

SPC (Y/N):

0.00

170 QC

Memo

0.00

<u>Pm 13/11/29.</u> MF 13-11-29

Quality Control

DQA:			Date:										DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFOI	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	r.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
Work Orde	٠					Rework			Skid-tube Crosstube		1	Water Jet	Engineering
Part N	lo					Scrap			Machining Small Fab			d. Eng. Coor.	Quality
NCR N	lo.	1				Use-as-is Suspected Unapproved		Thern	noforming Finishing Large Fab Composite	-	Rec/Stoi	re/Packaging Supplier	Other
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												-	
Doc/Data													
Equip/Tooling													
Handling/Pre						!							
Material													
Operator													
Offset/Setup	\Box	:											
Process	\Box												
Supplier													
Training							'						
Transport							İ						
Unapproved											1		
							FAI	ULT CA	TEGORY			N	
Landir	ng G	iear				General							••
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain		Г	Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are	Г	Part Incorre	ct 「	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		4	gned/off center		Positioned V	Vrong	
		Heat Trea	t			Cut Too Short		Mislab			Power Loss/	_	Other
		Inspection		Tube		Drawing		Misrea		_	·	- L	
	-	Marks/Ch	•			Drill Holes		Off-set					***
		Turning S				Finish		4	Calibration				
		Wave/Tw	•			Fit/Function		4	Sequence				

November-21-13 2:27:51 PM

Page 1

Work Order ID:

109440

Parent Item:

D3912-3

Parent Item Name:

Eyebolt Block

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000 303 BAR 1" X 1"		Purchased	No			100	f	11.8800	0.208	2.6273688			
•				Location		Loc Oty	Lo	c Code					
				MAT031		11.88							
				m12	6724	11.88			2.6	273628	JFC	2013	3-11-2

. *

DQA:			Date:						_				TRAGE
						WORK ORDER NON-	-CC	NFO	RMANCE / UP				AEROSPACE
QA Closed:		!	Date:							V	Vork Order u	pdate only	
Work Orde	sr.	!				DISPOSITION	ı			AGAINST D	EPARTMENT	/PROCESS	
Work Orac						Rework	ıl		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-		· · · · · · · · · · · · · · · · · · ·		_	Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۱o.					Suspected Unapproved			Large Fab	Composite		Supplier	
Root	-1				Dasci	ription of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty	Desci	or non-conformance		ief Eng			Date	Verification	QC inspector
Design		Date	эсер	Qiy		or non-comormance	<u> </u>	ier eng	Descri	ption	Dute	Vermedilon	Qo mapeeto.
Doc/Data	Н												
Equip/Tooling													1
Handling/Pre	П												
Material													
Operator							l						
Offset/Setup		:											
Process													
Supplier													
Training						•							
Transport	Ш												
Unapproved								<u>-</u>					
							FA	ULT CA	TEGORY				
Landi	$\overline{}$	1			_	General	_	1 .			_	-	
	Ш	Bending				Bend	<u> </u>	1	Program	_	Outside Din	ļ	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		-	Over/Unde	-	Set-up
	<u> </u>	Cracks		•	\vdash	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorre	⊢	Temperature/Cure
	\vdash	Crimp/Kir	nk/Ripple	/Wave		Burrs	\vdash	4 `	ion Incomplete/Un	· –	Part Lost/M		Weld
	L	Cuffs			-	Contamination	—	4	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
	<u> </u>	Crushing			\vdash	Countersink	\vdash	•	gned/off center	-	Positioned	_	Tother
	\vdash	Heat Trea		T b -	\vdash	Cut Too Short	\vdash	Mislabe		L	Power Loss	/surge _	Other
	\vdash	Inspectio	-	iupe	-	Drawing Drill Holes	\vdash	Misrea Off-set					
	-	Marks/Ch			\vdash	Finish	\vdash	4	Calibration				
	\vdash	Turning S			-	Fit/Function	\vdash	4	Calibration Sequence				
	1	Wave/Tw	กระเก เนเ	JE		FIG FUNCTION		Out of	sequence				

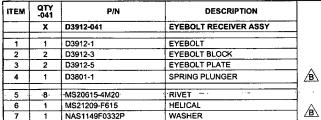
DART AEROSPACE LTD	Work Order:	109440
Description: Eyebolt Block	Part Number:	D3912-3
Inspection Dwg: D3912 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.30	+/-0.030	2.301			Vern.	172-01.
Ø0.129	+0.005/-0.001	Ø.129	/		17	
0.50 Ref	+/-0.030	.495			11	
R0.13	+/-0.030	R.125			R-G-	
0.500	+/-0.010	.497			Ulm	MI-PL
R0.125	+/-0.010	R.125			R-C-	711-06
0.63	+/-0.030	.625	_		Vem	711-06
0.750	+0.000/-0.020	.735			Al.	
0.38	+/-0.030	,375			4/	
1.500	+/-0.010	1.500			9)	
0.500 Pitch	+/-0.010	. 500			V	
0.800	+0.000/-0.010	.800			• 6	
0.400	+/-0.010	.400			14	
0.516	+0.015/-0.000	.522			, '	
1.00	+/-0.030	.990				

Measured by:	out	Audited by:	Preliminary Approval:	
Date:	13/11/28	Date: 3-11-29	Date:	

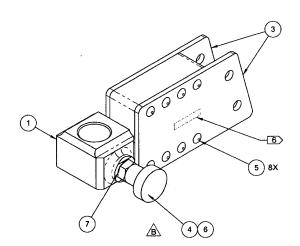
Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ rv	
В	12.05.15	Dwg Rev updated	KJ O	(WIII
			V/)	

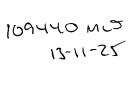


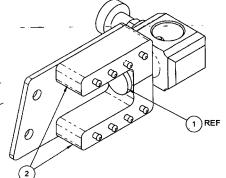
7



5







SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

1) MATERIAL: N/A

2) FINISH: NONE

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING

7) WEIGHT -041: 1.58 lbs

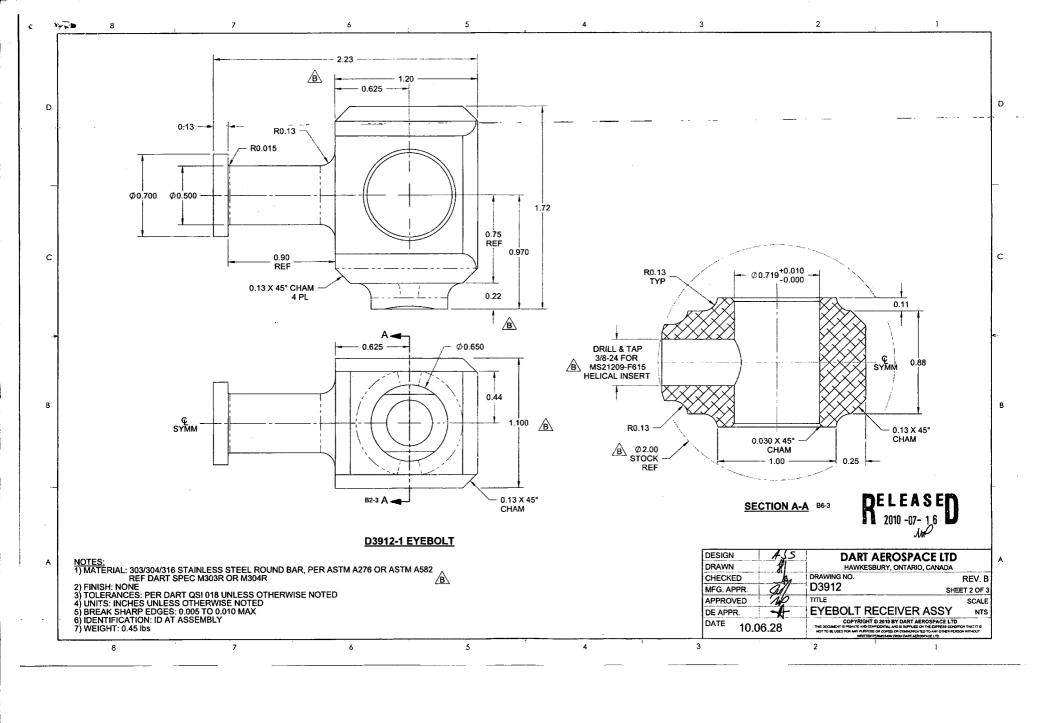
D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED; BOSS ADDED TO D3912-1. 10.06.28 NEW ISSUE 10.03.04 Α DESCRIPTION BY DATE REV.

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3912 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE EYEBOLT RECEIVER ASSY NTS DE APPR DATE

3

10.06.28

8



0.800+0.000 2.30 Ø0.129 THRU 1.500 4 PL 0.400 0.500 PITCH 0.50 REF 0.750 +0.000 -0.020 1.00 0.500 R0.125 TYP 0.516 +0.015 0.63

D3912-3 EYEBOLT BLOCK

1.500 R0.13 0.500 PITCH 0.25 0.517 1.000 1.500+0.020 2.00 REF Ø0.129 ϕ 0.257 0.125 8 PL 2 PL REF 3.65 3.69 REF

D3912-5 EYEBOLT PLATE

DESIGN	A55	DART AEROSPACE LTD	
DRAWN	181	HAWKESBURY, ONTARIO, CANADA	·
CHECKED	40	DRAWING NO.	REV. B
MFG. APPR.	all	D3912 SHE	ET 3 OF 3
APPROVED	149	TITLE	SCALE
DE APPR.	-#	EYEBOLT RECEIVER ASSY	NTS
DATE 10.0	06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVITE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION OF DISCUSSION OF THE PERSON OF COMMENCATED TO ANY OTHER PERSON.	

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

D

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs